









MAG ARC-WELDING METHOD AND WELDING APPARATUS.

Patent number: EP0478796
Publication date: 1992-04-08
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Classification:
 - International: **B23K9/09; B23K9/09;** (IPC1-7): B23K9/09
 - european: B23K9/09B2
Application number: EP19910907506 19910415
Priority number(s): WO1991JP00490 19910415; JP19900102102
 19900417; JP19900264493 19901001; JP19900311957
 19901116; JP19900418489 19901228; JP19900264494
 19901001

Also published as:

 WO9116168 (A1)
 US5508493 (A1)
 EP0478796 (A4)
 EP0478796 (B1)

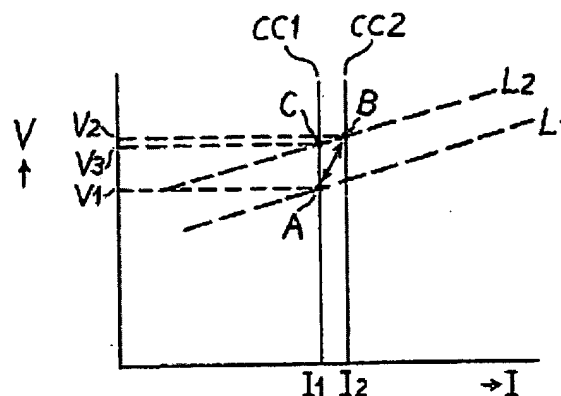
Cited documents:

 EP0333195
 JP61071178
 XP000126217
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Abstract of EP0478796

An MAG arc-welding method for obtaining bead appearance of a regular waveform or welded beads having a suitable sectional shape and an apparatus therefor. In this method, the output current of a welding power source is switched between a first welding current I_1 and a second welding current I_2 which is greater than the first welding current I_1 at a switching frequency of $F = 0.5$ to 25 Hz. The melting rate of wire is thus varied to alternately establish a first arc length L_r longer than 2 mm and a second arc length L_r which is longer than the first arc length, the ratio of the second welding current I_2 to the first welding current I_1 being from 1.03 to 1.20 . In addition to the welding method that changes the arc length by switching the welding output current without increasing or decreasing the rate for feeding the wire, the invention provides the welding method and apparatus for effecting the butt welding or the overlapped fillet welding making it possible to effect the welding irrespective of the presence of a great gap, i.e., for obtaining an excess metal by increasing the rate of feeding the wire by 5 to 20 % to increase the rate of melting the wire to compensate the lack of molten metal for filling the gap.



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